



Dart Aerospace Ltd.
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RBW6705G02732-3G

RBW6705G02732-3G

Job Sheet 193723



Part No: RBW6705G02732-3G

Job Qty: 2 pcs 10

Part Name: Tail Rotor Actuator Stroke Gag



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/22/19

Job Tracking No:

Due Date: 5/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6705G02731-3G Rev C IPP Rev A 17.11.20 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	5/15/19		0.00	1.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	2 pcs	5/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	2 pcs	5/15/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS MAY 23 2019 40 939
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S183542



Part: RBW6705G02732-3G

Job No: 193723

Serial No/Batch: S183542

Revision: C

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/23/19

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					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	2 pcs	5/15/19	0.00 0.00		QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	3-69

MAY 24 2019

Part Op 110 - Small Fab - Assemble as per DWG. Sheet 1 ***Cut lanyard at 12.0****
 Descriptions: 120 - QC5- Inspect part completeness to step on W/O Black ink stamp T/N on flag to fit as per DWG.
 130 - Identify as per dwg & Stock Location: _____ Black ink stamp T/N on flag as per DWG.
 140 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	4 Ea (2 ea)	110-Small Fab - 1	5150648
CL-2-C	Lanyard Wire	2 ft (1 ea)	110-Small Fab - 1	3119833
NAS1756-12	Remove Before Flight	2 Ea (1 ea)	110-Small Fab - 1	5134216
RBW6705G02732-3G-1	Stroke Gag, T/R Actuator	2 Ea (1 ea)	110-Small Fab - 1	515140016

515128526

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	3896T31	4	521	0
	CL-2-C	2	237	0
	NAS1756-12	2	204	0
	RBW6705G02732-3G-1	2	10	0

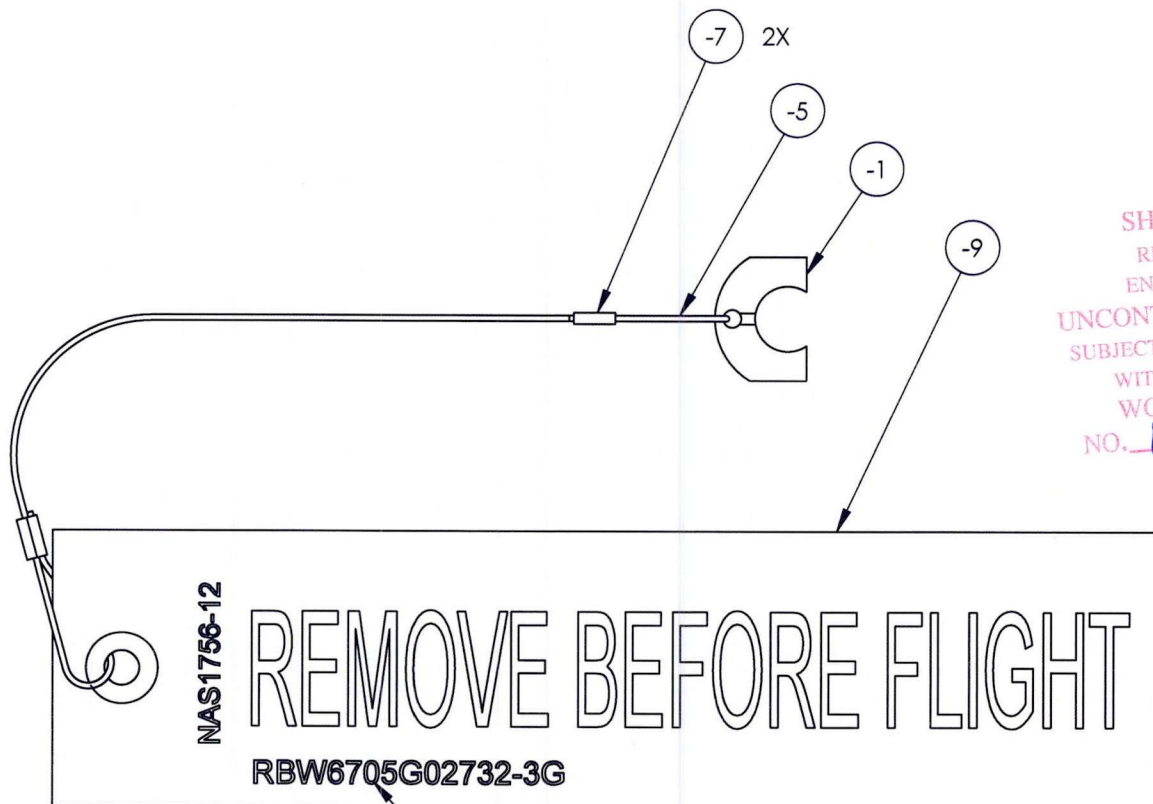
Part Specifications

Specifications could not be found.

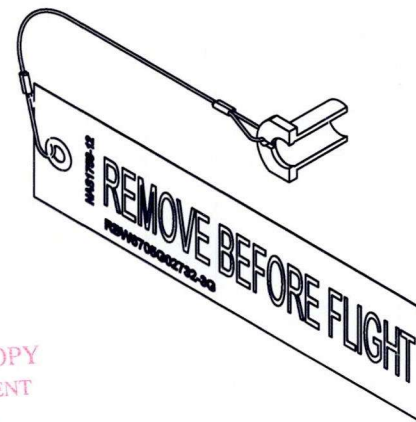
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		CORRECTED T/N ON -9. ADDED NOTE 2 & MADE SECTION A-A VIEW FOR CLARITY PER GE.	4/25/2011	RJC	RW
B		DELETED -3 KEY RING.	8/29/2012	RJC	SE
C	14-0135	CH'D TITLE BLOCK WAS RED BARN IS DART. CH'D T/N WAS RBW6705G02731-3G IS RBW6705G02732-3G. -1 ADDED DETAIL B. CH'D DIMS WAS .180 IS .188, WAS .997 IS .992, WAS 1.288 IS 1.531, WAS 1.498 IS 1.767. ADDED DIMS 1.35 & .02 X 45°.	8/18/2014	DPD	RJC



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193723 M.C.S
1904-27



NOTES:

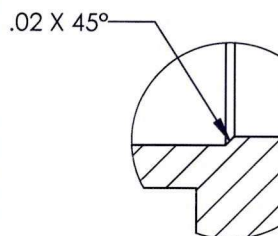
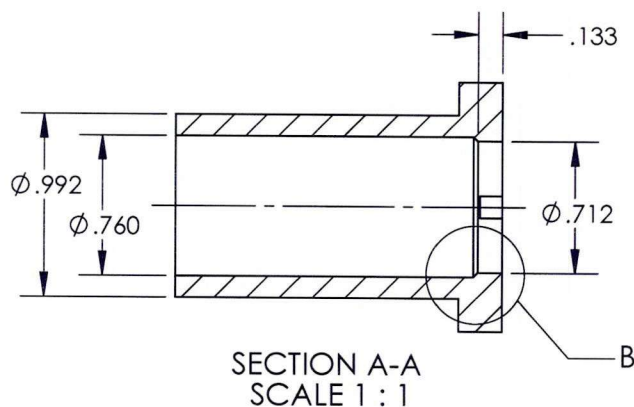
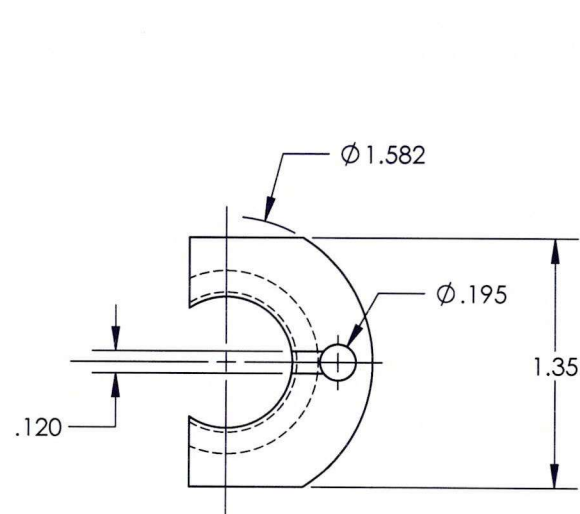
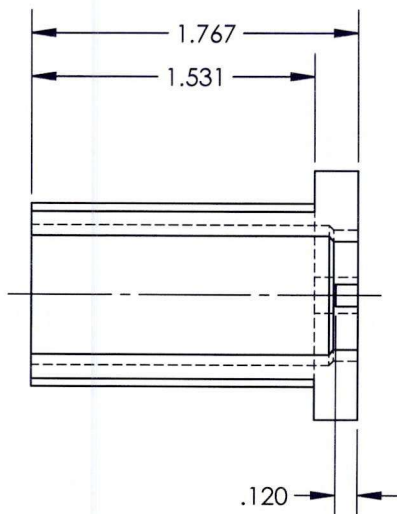
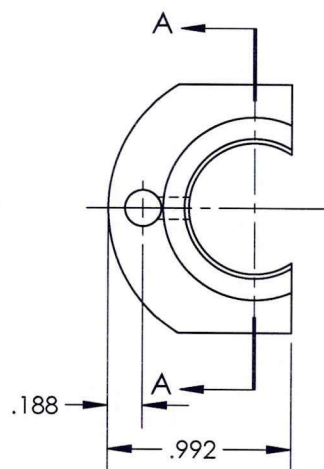
- PART OF KIT RBW6705G00132-3G.
- QUANTITY 1 PER KIT.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	STROKE GAG, T/R ACTUATOR	WHITE DELRIN	Ø1-3/4 X 1-5/8	2
		B/O	-5	1	LANYARD WIRE	COATED STEEL	Ø1/16 X 10 REID #CL2C	1
		B/O	-7	2	FERRULE	ALUMINUM	Ø1/16 X 3/8 MCMASTER-CARR #3896T31	1
		B/O	-9	1	REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12 AIRCRAFT HARDWARE	1

DART AEROSPACE	
TITLE STROKE GAG, T/R ACTUATOR	
DWG NO. RBW6705G02732-3G	REV C
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: PERRITT APPROVED: D Weil HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AGUSTA
SCALE 1:4	DATE 2/9/2011 SHEET 1 OF 2

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C	14-0135	-1 ADDED DETAIL B. CH'D DIMS WAS .180 IS .188, WAS .997 IS .992, WAS 1.288 IS 1.531, WAS 1.498 IS 1.767. ADDED DIMS 1.35 & .02 X 45°.	8/18/2014	DPD	RJC



(-1)
STROKE GAG, T/R ACTUATOR

NOTE:
SOME HIDDEN LINES OMITTED FOR CLARITY.

DART AEROSPACE	
TITLE STROKE GAG, T/R ACTUATOR	
DWG NO. RBW6705G02732-3G-1	REV C
MAT'L WHITE DELRIN	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± .5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA
SCALE 1:1	DATE 1/28/2010
SHEET 2 OF 2	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					